

Date: Tuesday, 4/18/2006 9:58:37 AM
 User: Kim Johnston

Process Sheet

split
83 06/06/12

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26646
 Estimate Number : 10336
 P.O. Number : *NIA*
 This Issue : 4/18/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : PURCHASED PARTS
 Previous Run : 25247
 Drawing Name : GAS SPRING
 Part Number : D2807
 Drawing Number : D2807 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : *NIA*
 Due Date : 5/5/2006
 Qty: *1550* Um: Each
 Written By : *See Comment Below*
 Checked & Approved By : *06.04.18*
 Comment : Est: D 05.06.21 Removed painting; Changed supplier
 KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *1035*

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

*C206104/19**(50)*

2.0 SXF6S6050080S6L115N GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 SUPPORT PROP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

*06/06/12**(50)*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06.06.12 *(50)*

5.0 D28073 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

2 D2807-3 Lug Batch: *B26625 (20)* *B27 #52 (4)*

12 *(12)*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 26646

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig.

2-Remove lettering and logo with wash and wipe.

SAO 06-06-12

12

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/06/12

(12)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SA 06/06/12

(12)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

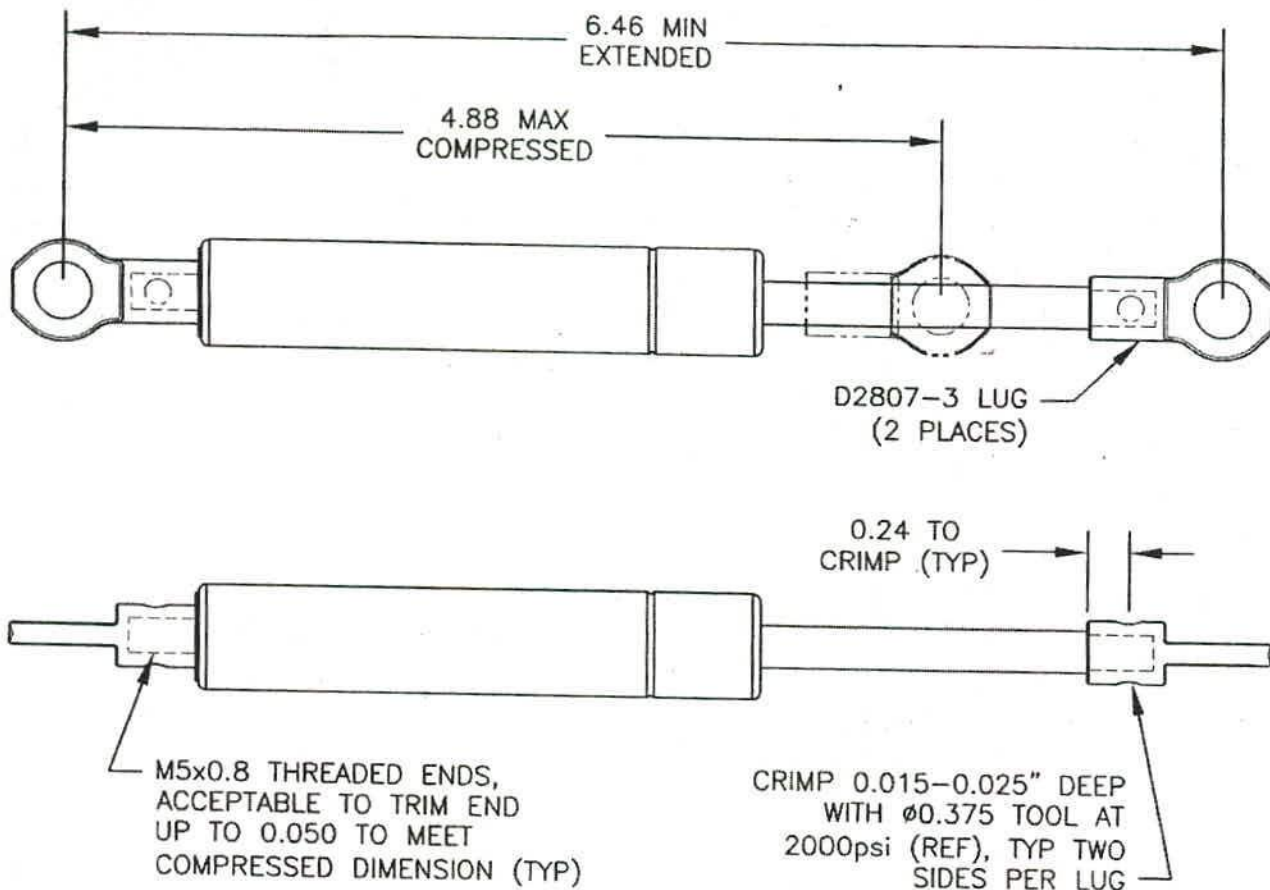
SA 06/06/13

(12)

Job Completion



u 06/06/13

DART**RELEASED**
#05.06.16

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2807
DATE		TITLE
05.05.25		GAS SPRING
A	00.11.03	NEW ISSUE
B	05.03.16	ADD FINISH
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG
		SCALE
		1:1
		SHEET 1 OF 2
		REV. C

D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

2) SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

INVOICE TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7
CANADA

DART AEROSPACE LTD
SHIP WITH AE: 57561 VIA
FEDEX P-1 OVERNIGHT SVCE
ACCOUNT NO: 15179324-0

V70606

A/C No.

20111

AREA

46

CUSTOMER REF. No.

P000001035

V.A.T. REGISTRATION No. GB 738 8577 71

W ORDER

NUMBER

QTY. ORDERED

XXXXXXXXXX

168336

QTY. SHIPPED

50

BATCH No.

TY. ORDERED

50

U of M

QTY. ORDERED

XXXXXXXXXX

EA

PART NUMBER

SXF6050500047

SXF6 S6 050 0 80 S6 L 20mm

32AWS 115N NNN SP1

DESCRIPTION

DUE DATE

08JUN06

SPECIAL INSTRUCTIONS

SHIP DATE

CARRIER CODE

WEIGHT

DESPATCH TICKET

07JUN06

Cam 001

Arvin Motion Control Limited.
Main Tel: +44 (0)116 274 3600
Sales Tel: +44 (0)116 274 3622
Accounts Tel: +44 (0)116 274 3616

15 New Star Road, Leicester, LE4 9JD, UK
Main Fax: +44 (0)116 274 3620
E-mail - info.amcl@arvinmeritor.com
Website: www.camloc.com

FED EX
8490 2198 6376

YOUR ORDER WAS PACKED BY

Confirmed that the whole of the supplies detailed herein
have been inspected and tested and unless otherwise stated
conform in all respects with the contract/purchase order
requirements.

SIGNED